

S.FAB

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RBT18561
Job Sheet 177959



Part No: RBT18561

Job Qty: 1 ea

Part Name: Bell 407 Field Maintenance



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/23/18

Job Tracking No:

Due Date: 10/9/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT18561 Rev3 (TEO17-640) IPP Rev A 17.12.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/9/18	10/9/18	0.00	0.00	Start Up Small Fab-4		7/10/18
110	Small Fab	1 pcs	10/9/18	10/9/18	0.00	1.00	Small Fab-9		
120	QC	1 pcs	10/9/18	10/9/18	0.00	0.00	QC#5		
130	Packaging	1 pcs	10/9/18	10/9/18	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea	10/9/18	10/9/18	0.00	0.00	QC21		

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
26 3896T31 - MAT	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	90-Start up Operation	5038398
40 97524A032 - MAT	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	5089128
212 APP-1700-E	Case	1 Ea (1 ea)	90-Start up Operation	5044386
CL-2-C - MAT	Lanyard Wire	1 ft (1 ea)	90-Start up Operation	5093863
RB H4713	Drain Hose	1 Ea (1 ea)	90-Start up Operation	5079052
74 RB H4749	Drain Hose	1 Ea (1 ea)	90-Start up Operation	5079052
RB23006782	Adapter, Torque Turbine Attach Lower Nut	1 Ea (1 ea)	90-Start up Operation	5045929
GA RB23006783	Adapter, Torque Turbine Attach Upper Nut	1 Ea (1 ea)	90-Start up Operation	5045929
RB23007615	Power Turbine Support Cleaning C-30 & C-47	1 Ea (1 ea)	90-Start up Operation	5031040
RB23007638	Fuel Injector Wrench	1 Ea (1 ea)	90-Start up Operation	5119024
RB41011 MAT	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	5053653
141D RBBP1425-101	Input Drive Shaft Tool (K-Flex)	1 Ea (1 ea)	90-Start up Operation	
141C RBE2-10-1	Fuel System Cartridge Removal Tool	1 Ea (1 ea)	90-Start up Operation	

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Container No: S121597



Part: RBT18561

Job No: 177959

Serial No/Batch: S121597

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.

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CANADA

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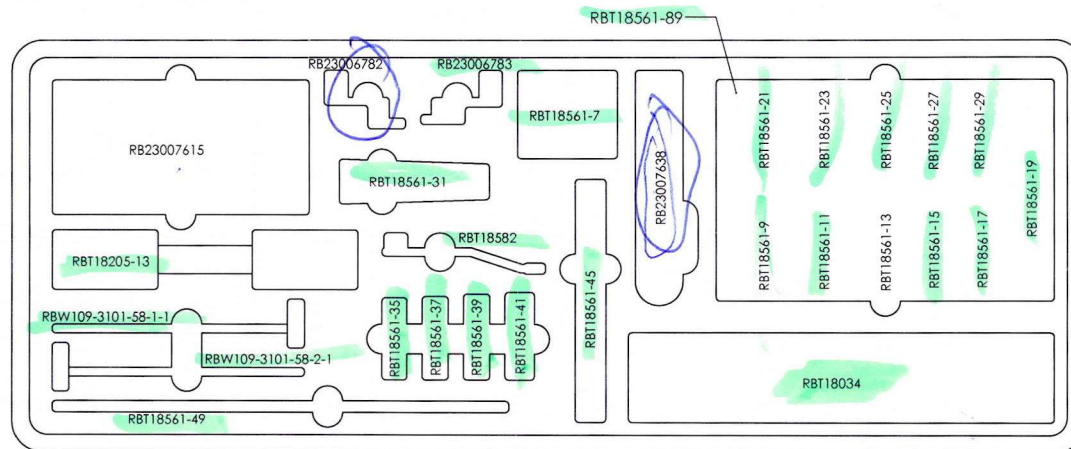
Date: 10/25/18

			Operation	
	RBT112800 145	Power Take Off Seal Installation Tool	1 Ea (1 ea) 90-Start up	
			Operation	5053627
144	RBT18025-13	Linear Scale (50 lbs)	1 Ea (1 ea) 90-Start up	
			Operation	5065446
59	RBT18034	Main Rotor Pitch Link Protectors	1 Ea (1 ea) 90-Start up	
			Operation	5043812
145	RBT18538	Pilot, Co-Pilot Seat Brace	1 Ea (1 ea) 90-Start up	
			Operation	5054287
145B	RBT18560	Engine Gearbox Seal Puller	1 Ea (1 ea) 90-Start up	
			Operation	5057990
85	RBT18561-11	Needle Nozzle Grease Gun	2 Ea (2 ea) 90-Start up	
			Operation	5036192
	RBT18561-13	Relay Base Removal	1 Ea (1 ea) 90-Start up	
			Operation	5043350
	RBT18561-15	Extract Tool - Blue	2 Ea (2 ea) 90-Start up	
			Operation	5043351
	RBT18561-17	Extract Tool - Red	2 Ea (2 ea) 90-Start up	
			Operation	5043352
	RBT18561-19	Extract Tool - Green	2 Ea (2 ea) 90-Start up	
			Operation	5079672
	RBT18561-21	Extract Tool - Terminal Block	1 Ea (1 ea) 90-Start up	
			Operation	5043354
	RBT18561-23	Extract Tool - Terminal Block	1 Ea (1 ea) 90-Start up	
			Operation	5043355
	RBT18561-25	Relay Removal	1 Ea (1 ea) 90-Start up	
			Operation	5079675
	RBT18561-27	Posi-Drive Bits-Main Rotor Beanie	2 Ea (2 ea) 90-Start up	
			Operation	5045223
	RBT18561-29	Extraction Tool	1 Ea (1 ea) 90-Start up	
			Operation	5079676
	RBT18561-31	10X Magnifier Glass	1 Ea (1 ea) 90-Start up	
			Operation	5075955
	RBT18561-35	Offset 5/16 Torque Adapter	1 Ea (1 ea) 90-Start up	
			Operation	5044607
	RBT18561-37	Offset 3/8 Torque Adapter	1 Ea (1 ea) 90-Start up	
			Operation	5078464
	RBT18561-39	Offset 1/2 Torque Adapter	1 Ea (1 ea) 90-Start up	
			Operation	5078465
	RBT18561-41	Offset 9/16 Torque Adapter	1 Ea (1 ea) 90-Start up	
			Operation	5078466
	RBT18561-45	A/C Belt Tensioner	1 Ea (1 ea) 90-Start up	
			Operation	5077641
4	RBT18561-49	Tygon Hose	1 ft (1 ea) 90-Start up	
			Operation	5048059
85	RBT18561-7	Crowfoot	1 Ea (1 ea) 90-Start up	
			Operation	5078467
212	RBT18561-75	Bottom Foam (3 x 13-3/4 x 36, Ethafoam 220, Black)	1 Ea (1 ea) 90-Start up	
			Operation	5044388
212	RBT18561-77	Top Shelf Foam (2-1/16 x 13-3/4 x 35-1/2, Ethafoam 220, Black)	1 Ea (1 ea) 90-Start up	
			Operation	5044394
212	RBT18561-79	Stiffener (0.236 x 13-3/4 x 35-1/2, Coroplast, Black)	1 Ea (1 ea) 90-Start up	
			Operation	5044400
85	RBT18561-81	Contents & Location Placard	1 pcs (1 ea) 90-Start up	
			Operation	5048414
78	RBT18561-89	Storage Box	1 Ea (1 ea) 90-Start up	
			Operation	5043316
85	RBT18561-9	Insert Tool-Whelen Connectors	1 Ea (1 ea) 90-Start up	
			Operation	5046781
146	RBT18582	Tail Rotor Gear Box Torque Adapter	1 Ea (1 ea) 90-Start up	
			Operation	5040669
	RBT400213	407 Trim Tab Bender	1 Ea (1 ea) 90-Start up	
			Operation	5123036
	RBT400214	Trim Tab Bending Gauge	1 Ea (1 ea) 90-Start up	
			Operation	
136A	RBT400325	Tail Boom Nut Socket (407)	1 Ea (1 ea) 90-Start up	
			Operation	50406
102	RBW109-3101-58-1-1 Hammer, Steel		1 Ea (1 ea) 90-Start up	
			Operation	5121
102	RBW109-3101-58-2-1 Hammer, Aluminum		1 Ea (1 ea) 90-Start up	
			Operation	51

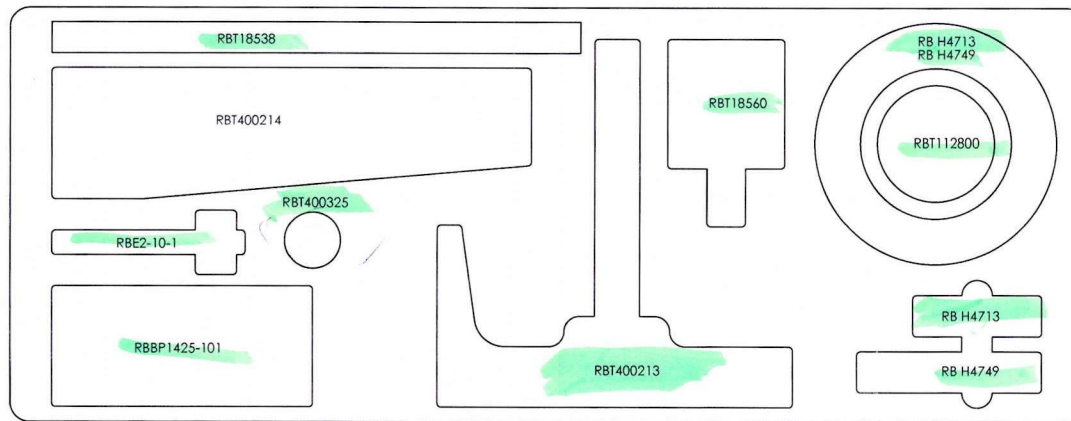
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	2	1,033	0
	97524A032	4	523	0
	APP-1700-E	1	21	0
	CL-2-C	1	348	0
	RB H4713	1	0	0
	RB H4749	1	6	0
	RB23006782	1	0	0
	RB23006783	1	1	0
	RB23007615	1	0	0
	RB23007638	1	0	0
	RB41011	1	789	0
	RBBP1425-101	1	0	0
	RBE2-10-1	1	4	0
	RBT112800	1	4	0
	RBT18025-13	1	20	0
	RBT18034	1	6	0
	RBT18538	1	4	0
	RBT18560	1	4	0
	RBT18561-11	2	18	0
	RBT18561-13	1	9	0
	RBT18561-15	2	20	0
	RBT18561-17	2	20	0
	RBT18561-19	2	20	0
	RBT18561-21	1	10	0
	RBT18561-23	1	10	0
	RBT18561-25	1	10	0
	RBT18561-27	2	16	0
	RBT18561-29	1	9	0
	RBT18561-31	1	7	0
	RBT18561-35	1	8	0
	RBT18561-37	1	10	0
	RBT18561-39	1	10	0
	RBT18561-41	1	10	0
	RBT18561-45	1	10	0
	RBT18561-49	1	22	0
	RBT18561-7	1	10	0
	RBT18561-75	1	8	0
	RBT18561-77	1	8	0
	RBT18561-79	1	8	0
	RBT18561-81	1	5	0
	RBT18561-89	1	10	0
	RBT18561-9	1	11	0
	RBT18582	1	13	0
	RBT400213	1	0	0
	RBT400214	1	0	0
	RBT400325	1	4	0
	RBW109-3101-58-1-1	1	4	0
	RBW109-3101-58-2-1	1	3	0
Part Specifications				
Specifications could not be found.				

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TOP SHELF



BOTTOM CUSHION

TOOL LAYOUT

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CORRECTED -11 B/O P/N FROM 6Y900 TO GY900.	1/14/2013	RJC	SE
1		CHD -75 TOOL LAYOUT, ADDED NEW DESIGN FOR DRAIN HOSES & CUTOUPS FOR INDIVIDUAL QUIBLS (RB H4713, RB H4749), MOVED RBT112800, CHD SQUEEZE BOTTLE DEPIHS FROM 2.65 TO 2.35 & 3.43 TO 3.08.	1/14/2013	RJC	SE
1A		-7 CHD BOM INFO WAS 1/2 DRIVE IS 3/8 DRIVE, -13 NUMBER WAS M6106/32-002 IS M6106/32-001.	3/8/2013	BIM	SE
1B		CORRECTED T/N ON BOTTOM TOOL LAYOUT WAS RBT400235 IS RBT400325.	1/21/2014	RJC	RJC
2	16-0139	-75 & -77 CHD MATERIAL & SUPPLIER WAS Y20 BLACK, I.R. SPECIALTY IS ETHAFOAM 220, BLACK, CASE SOLUTIONS, -75 DELETED RBT18561-59 & RBT18561-61 FROM KIT AND CHD TOOL LAYOUT, CHD DIM WAS 4X R.64 IS 3X .45 X 45°, -77 ADDED CUTOUPS FOR RBW109-3101-58-1, RBW109-3101-58-2 AND RBT18034, DELETED -33 AND ADDED -34 AND CHD CUTOUP FOR NEW SCALE, -79 CHD DIM WAS 28.44 IS 35.50, ADDED BLACK TO COROPLAST MATERIAL CALLOUT, -81 UPDATED WITH NEW S AND DELETED TOOLS, CHD PAPER WAS WHITE IS RED.	9/2/2016	RJC	JAG
3	16-0251	CORRECTED DWG. TITLE WAS FIELD TOOL KIT IS 407 FIELD MAINTENANCE KIT, CORRECTED T/N WAS RBW109-3101-58-1 IS RBW109-3101-58-1-1, WAS RBW109-3101-58-2 IS RBW109-3101-58-2-1, -31 ADDED B/O INFO (MCMaster-CARR #6485113), -75, -77, -79, -81 CHD DWG. TO SHEET METAL TOLERANCE, -75, -77 ADDED DIM 4X R.64, -81 CORRECTED T/N WAS RBW109-3101-58-1 IS RBW109-3101-58-1-1, WAS RBW109-3101-58-2 IS RBW109-3101-58-2-1.	12/5/2016	RJC	SM

TEO ATTACHED

DART AEROSPACE																	
TITLE 407 FIELD MAINTENANCE KIT																	
DWG NO RBT18561	REV 3																
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>FINISH</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>SPEC</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td></td> <td>.XX ± .01 ANGLES ± .5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES ± 125°</td> </tr> <tr> <td colspan="2">1. BREAK ALL SHARP EDGES</td> </tr> <tr> <td colspan="2">2. DIMENSIONAL LIMITS APPLY</td> </tr> <tr> <td colspan="2">3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	FINISH	DIMENSIONS ARE IN INCHES	SPEC	.XXX ± .005 FRACTIONS ± 1/8		.XX ± .01 ANGLES ± .5°		.X ± .1 SURFACES ± 125°	1. BREAK ALL SHARP EDGES		2. DIMENSIONAL LIMITS APPLY		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
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DRAWN BY: CLOUGH																	
CHECKED: DUERFELDT																	
OPPS APPR: ANDERSON																	
QA APPR: LINDSAY																	
APPROVED: MACKOVJAK																	
SCALE 1:4	DATE 12/28/2011																
SHEET 1 OF 6																	